

Date: Thursday, 17/01/2008 3:13:12 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 205 SKIDTUBE "I" BEAM
 Job Number : 36872
 Estimate Number : 10346
 P.O. Number : Part Number : D2596
 This Issue : 17/01/2008 S.O. No. : Drawing Number : D2596 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : LANDING GEAR Drawing Revision : D
 Previous Run : 36803 Material :
 Written By : Due Date : 24/01/2008 Qty: 10 Um: Each
 Checked & Approved By :
 Comment : Est: D 99-02-02 Changed QA to QC, Added Step 6 and Cost D
 M
 Est Rev:E 07-07-09 Incorporated DEO 9183 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25003100 Extr'n -"I" Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Extrusion "I" Beam Web 4"
 Pick;

Qty	Part Number	Description	Batch
1	D2500-3-100	Extrusion	B33940 ID M 8-1-21

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
 1- Cut D2500-3-100 to length: 99.5"
 2- Use Jig DT8093 to drill pilot holes #30
 3- Open to 0.630" diameter as per Dwg D2596
 4- Deburr

M ID 8-1-21
 SL 8-1-21
 M 8-1-21 ID

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Acid Etch and Alodine per QSI 005 4.1

SL 8-1-23

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 8-1-23 ID

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 SKIDTUBE "I" BEAM

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L6

SL 8-1-23

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)
D 08/01/08

Job Completion



mi 2008/1/23

U

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

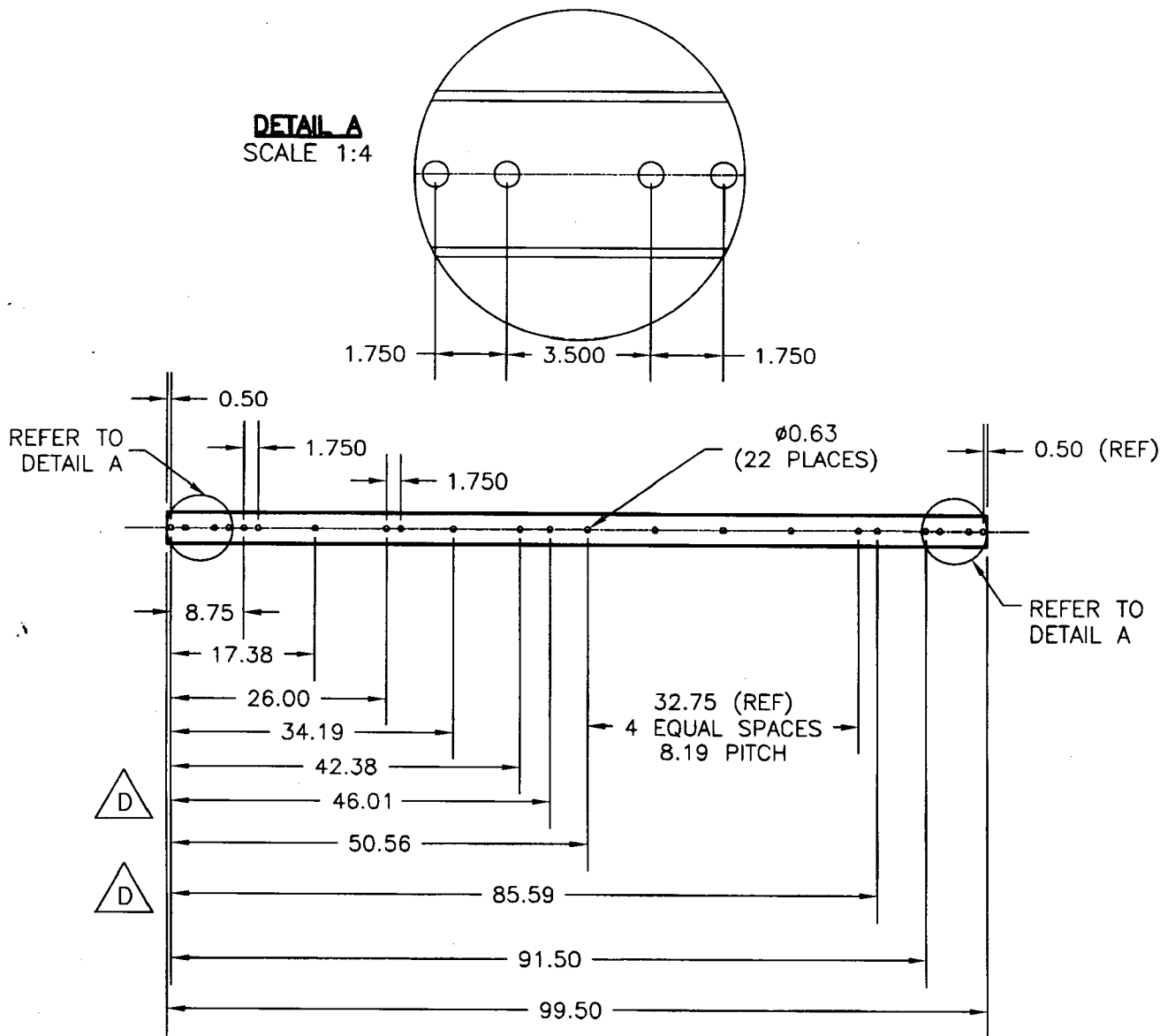
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.06.88

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
PA	gt		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
gt	gt	D2596	
DATE	TITLE	SCALE	
07.04.17	205 WEB	1:20	
A	96.09.16	NEW ISSUE	
B	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

W/B
9/8/92

